

Work Order ID 124981

124981

Page 1

Tuesday, September 30, 2014 1:29:47 PM

Item ID: D4635-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Panel, RH
 Start Date: 9/30/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/10/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1409-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	E								

100
100
 Thermoform
 Thermoforming Machine
 HAND FINISHING THERMOFORMING
 Memo
 Cut Blanks
 0.00
 0.00
 DAS
 27
 9-30
 M110/2

105
105
 HandThermo
 Hand Finishing Thermoforming
 Dry Material
 Memo
 Dry Sheet as per QSI022 POLYCARBONATE
 Temp: 245 d
 Time IN: 5:00 P
 Time OUT: 6:00 P
 OCT 01 2014
 Per.....
 DAS
 27
 9-30
 M110/2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Start Date: 9/30/2014 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5 Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev A	0.00 0.00				S/m/B 14/11/12			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					15-02-05		DAS 9 9-89
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00							DAS 27 9-89 FEB 05 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLG 15-02-06
MF
15-2-5

DQA: _____ Date: _____



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Picklist Print

Tuesday, September 30, 2014 1:29:50 PM

Page 1

Work Order ID: 124981

124981

Parent Item: D4635-2

D4635-2

Parent Item Name: Fwd Ceiling Panel, RH

Start Date: 9/30/2014

Required Date: 10/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update
13/07/09 DL IPP Rev D Dwg. Update, Material
Change 13/12/18 DL IPP Rev. E Dwg. Update 14/01/09 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	3,338.313	25.27	26			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

DAS

27

9-30

14/10/12

Location

Loc Qty

Loc Code

MAT023

3338.31332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

21.92

m129738

2221.95

26

DQA: _____ Date: _____



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Equip/Tooling									
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Supplier									
Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 124981
Description: RH Fwd Ceiling Panel		Part Number: D4635-2
Inspection Dwg: D4635	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/-0.030	14.00	✓		ENC7-09	
28.00	+/-0.030	28.00	✓		TH-01	
42.00	+/-0.030	42.00	✓			
55.00	+/-0.030	55.00	✓			
5.00	+/-0.030	5.00	✓			
12.6	+/-0.100	12.6	✓			
18.6	+/-0.100	18.6	✓			
38.4	+/-0.100	38.4	✓			
44.4	+/-0.100	44.4	✓			
1.3	+/-0.100	1.294	✓			
7.0	+/-0.100	7.0	✓			
7.00	+/-0.030	7.00	✓			
Ø2.03	+0.012/-0.001	2.029	✓			
Ø0.191	+0.005/-0.001	0.193	✓			
Ø3.50	+0.012/-0.001	3.561	✓			
3.300	+/-0.010	3.306	✓			
1.650	+/-0.010	1.6504	✓			
Ø0.129	+0.005/-0.001	0.1285	✓			
1.300	+/-0.010	1.298	✓			
0.650	+/-0.010	0.6497	✓			
0.35 - 0.40	+/-0.030	0.394	✓			
0.30	+/-0.030	0.324	✓			
0.50	+/-0.030	0.526	✓			

Measured by: Smb
Date: 14/11/12

Audited by: DAS 9 289
Date: 15-02-06

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	

DQA: _____ Date: _____



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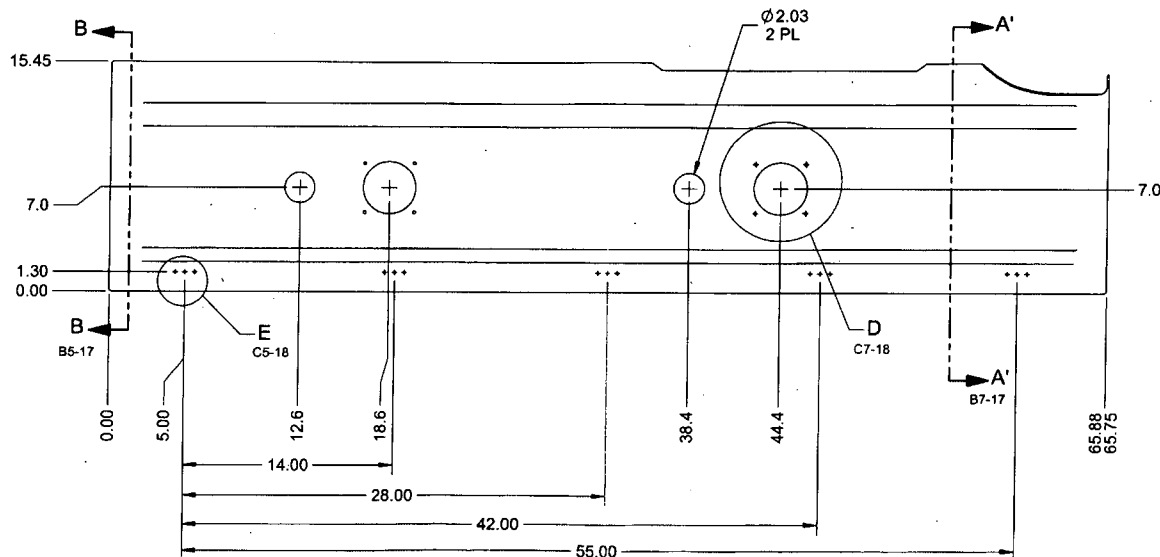
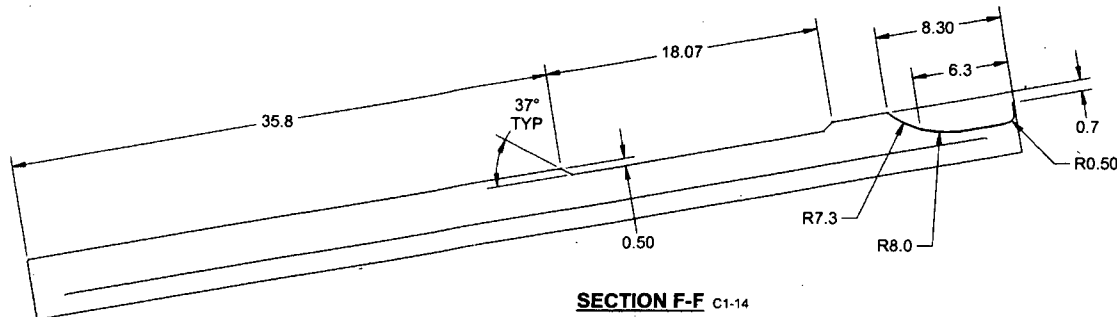
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FAULT CATEGORY

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124981 M15

14-09-30



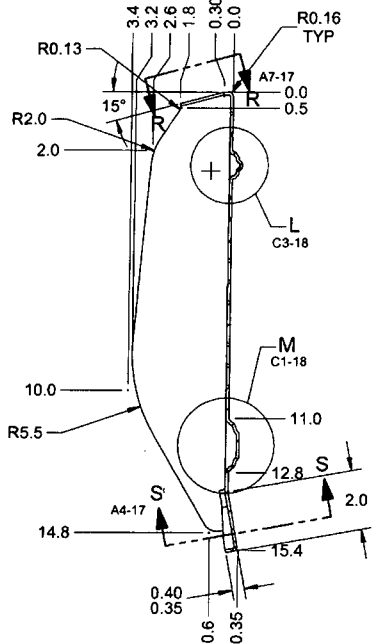
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

- 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.37 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) TRIM D4635-2 PER TOOL DT9840
 - 10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
- MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

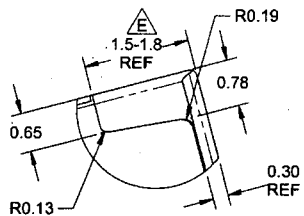
D4635-2 RH, FWD CEILING PANEL

RELEASED
2014-01-22

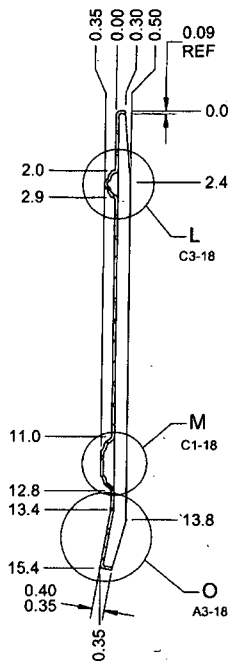
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	AS	D4635	SHEET 14 OF 18
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	OUTBOARD CEILING PANELS	NTS
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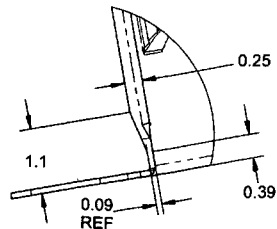
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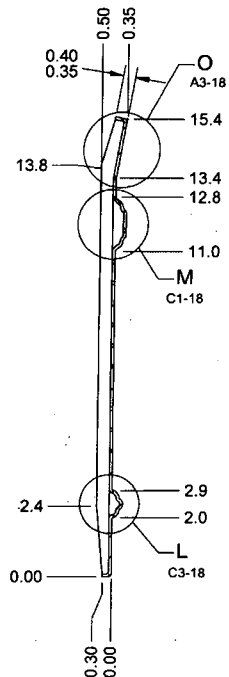
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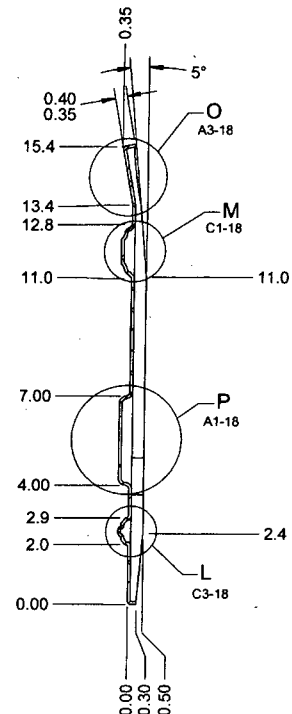
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AUXILIARY VIEW S-S B7-17
SECTION S-S' OPPOSITE
SCALE 2X



SECTION G-G B4-15
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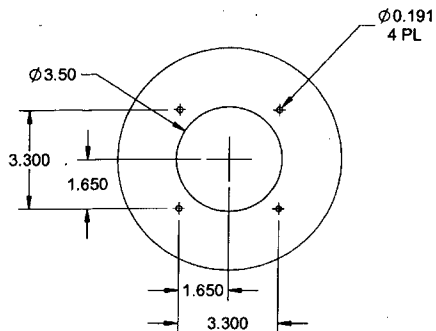


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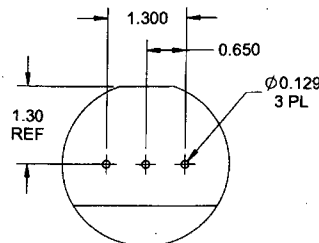
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DRAWN	RF		
CHECKED	DL	DRAWING NO.	REV. E
MFG. APPR.	DL	D4635	SHEET 17 OF 18
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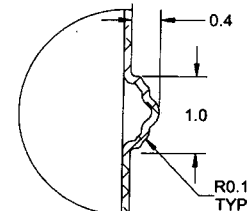
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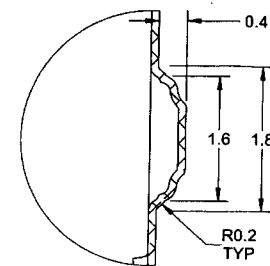
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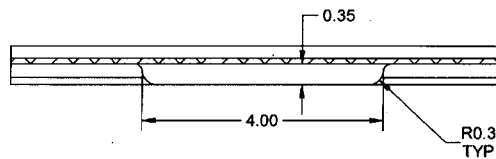
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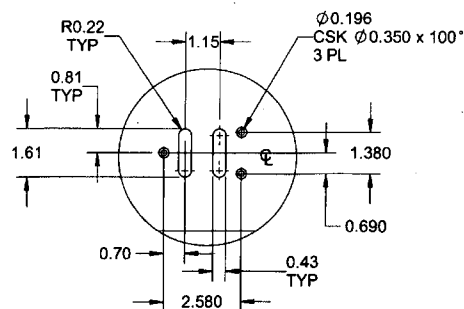
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C5-17
C7-17



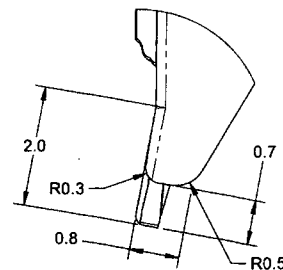
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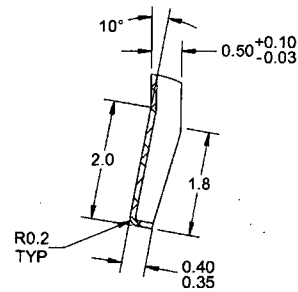
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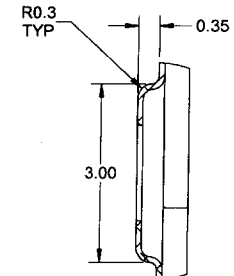
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DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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8 7 6 5 4 3 2 1